

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020187**Date Inspected:** 27-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 7EW / North of Bay 14

This Caltrans QA inspector observed shielded metal arc welding (SMAW) in progress. Welders are identified as 037952 and 045268 welding complete joint penetration (CJP) weld repairs in the 4G position using welding procedure specification WPS-345-SMAW-4G(4F)-Repair-1. The weld is identified as SEG041A-001. ZPMC QC inspectors are identified as Mr. Wang Xiang Pin and certified welding inspector (CWI), Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DE / Bay 14

This Caltrans QA inspector observed flux cored arc welding (FCAW) in progress. Welder is identified as #058551 welding complete joint penetration weld (CJP), identified as #SSD17-PP105-088 in the 2G position using WPS-B-T-2232-TC-U4b-F. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and CWI, Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DE / Bay 14

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #214945 welding Fillet Weld (FW), identified as #DP403-001-132 and 133 in the 2F position using WPS-B-T-2132. ZPMC QC inspectors are identified as Mr. Zhong Guo Hui and CWI, Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with the WPS.

WELDING INSPECTION REPORT

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OBG Segment Name: 11DW / Bay 14

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #202122 welding CJP weld, identified as #SEG071*-004 in the 1G position using WPS-B-T-2231-B-U2-F. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 9CW / North of Bay 17

This Caltrans QA inspector observed FCAW in progress. Welder is identified as #045280 welding CJP weld, identified as #SSD13-PP78-132 using WPS-B-T-2232-TC-U4b-F-1. ZPMC QC inspectors are identified as Mr. Li Ping and CWI, Mr. Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
